

Work Order ID 68790

Thursday, April 21, 2011 8:13:01 AM



Page 1

Item ID: D3220-042

Accept



Setup Start



Revision ID:

Item Name: Doubler Assembly

Stop



Start Date: 4/20/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 4/25/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: *14*Date: *4/20/11*

Tooling:

Date:

Run Start



QC: _____

Date: _____

SPC (Y/N):

Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3220	B

100



FLOW WATER JET

Waterjet

Memo

0.00

B 11-5-4

FLOW CNC Waterjet

2024.055

1-Cut D3220-2 as per Dwg D3220

Dwg Rev: _____

Prog Rev: _____

2-Deburr if necessary

110



QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

0.00

B 11-5-4

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120



QC

Quality Control

QC8- Inspect parts - second check

0.00

0.00

0.00

0.00

0.00

0.00

130



Small Fab

Small Fab

0.00

0.00

0.00

0.00

Small Fab

Memo

1-Deburr

2-C'sink D3220-2 as per Dwg D3220

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

0.00

0.00

0.00

0.00

0.00

0.00

0.00

Sulsky

X4

Ep 4/05/04 (4)

X4

-042

W/O:		WORK ORDER CHANGES					
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Page 4

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Start Date: 4/20/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 4/25/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC5- Inspect part completeness to step on W/O

0.00

0.00 1105109

+4

-042



QC

Quality Control

190

Identify as per dwg & Stock Location: 179

0.00

115/9

SF Q



Packaging

Packaging

Memo

0.00

200

QC21- Final Inspection - Work Order Release

0.00



QC

Quality Control

Memo

0.00

115/9 JJ

MF
11-05-09

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Thursday, April 21, 2011 8:13:07 AM

Page 1

Work Order ID: 68790



Parent Item: D3220-042



Parent Item Name: Doubler Assembly

Start Date: 4/20/2011

Required Date: 4/25/2011

Comments: IPP Rev:A New Issue 05-11-06 JLM
IPP: B 06.11.15 waterjet EC

Start Qty: 4.00

Start Qty: 4.00

Required Qty: 4.00

Required Qty: 4.00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	68790
Description: Doubler	Part Number:	D3220-2
Inspection Dwg: D3220	Rev: A1	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	R	Audited by:	S	Prototype Approval:	N/A
Date:	11-5-4	Date:	11/15/04	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.09.06	New Issue	P/O D3220-042	KJ/JLM <i>[initials]</i> <i>[initials]</i>

W/O:		WORK ORDER CHANGES						
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NOTE: Date & initial all entries

8

7

6

5

4

3

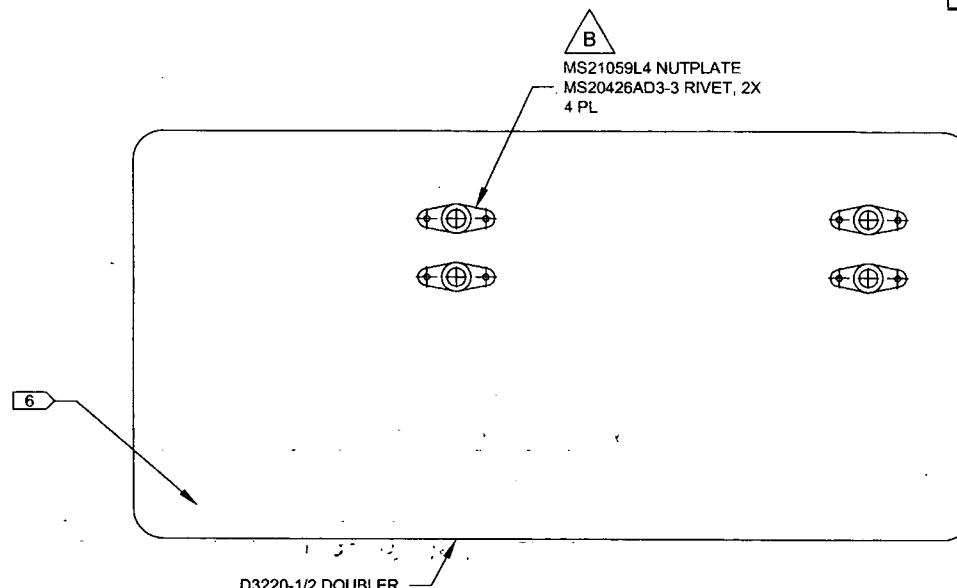
2

1

D

D

Item	Qty -041	Qty -042	Part Number	Description
1	X		D3220-041	DOUBLER ASSEMBLY
2		X	D3220-042	DOUBLER ASSEMBLY
3	1		D3220-1	DOUBLER
4		1	D3220-2	DOUBLER
5	4	4	MS21059L4	NUTPLATE
6	8	8	MS20426AD3-3	RIVET



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 68790
01/11/09-21

RELEASED
2009-09-09

D3220-041 DOUBLER ASSEMBLY (SHOWN WITH D3220-1 DOUBLER)
D3220-042 (OPPOSITE)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3220-04X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: D3220-041 = 0.53 lbs
D3220-042 = 0.53 lbs

B	DRAWING UPDATED TO CURRENT STANDARDS. Ø0.316 WAS Ø0.323 (ZN C8-2, B4-3); MS20426AD3-3 WAS MS20426AD3-4 (ZN D4-1); CORRECT TYPO NOTE 1 (ZN A8-2, A8-3); REF PAR 09-025		RF	09.07.08
A	NEW ISSUE		CP	03.10.16
REV.	DESCRIPTION	BY	DATE	
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	RF			
CHECKED		DRAWING NO.	REV. B	
MFG. APPR.		D3220	SHEET 1 OF 4	
APPROVED		TITLE	SCALE	
DE APPR.		DOUBLER	NTS	
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8

7

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1

A

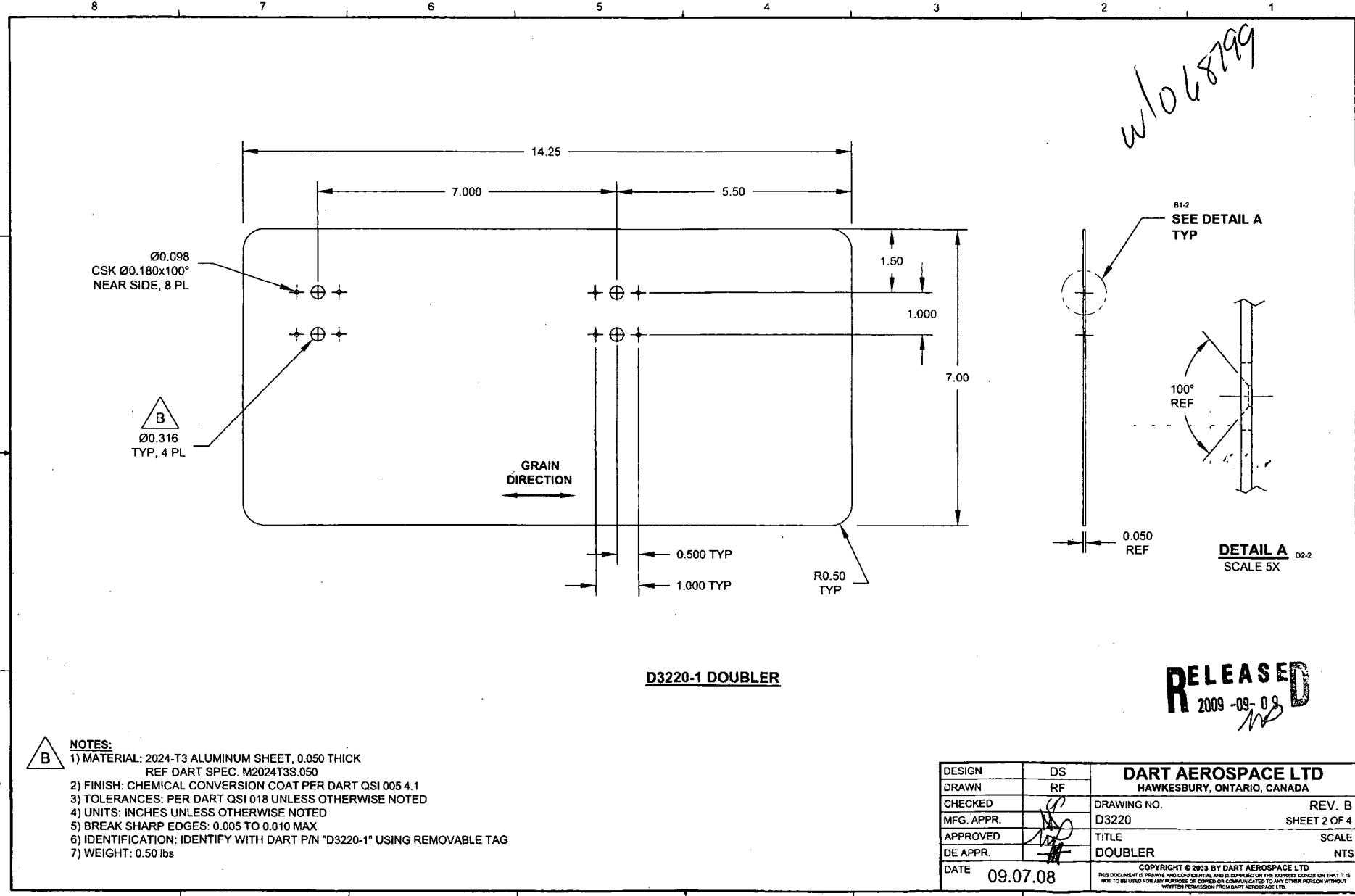
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NOTE: Date & initial all entries



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8 7 6 5 4 3 2 1

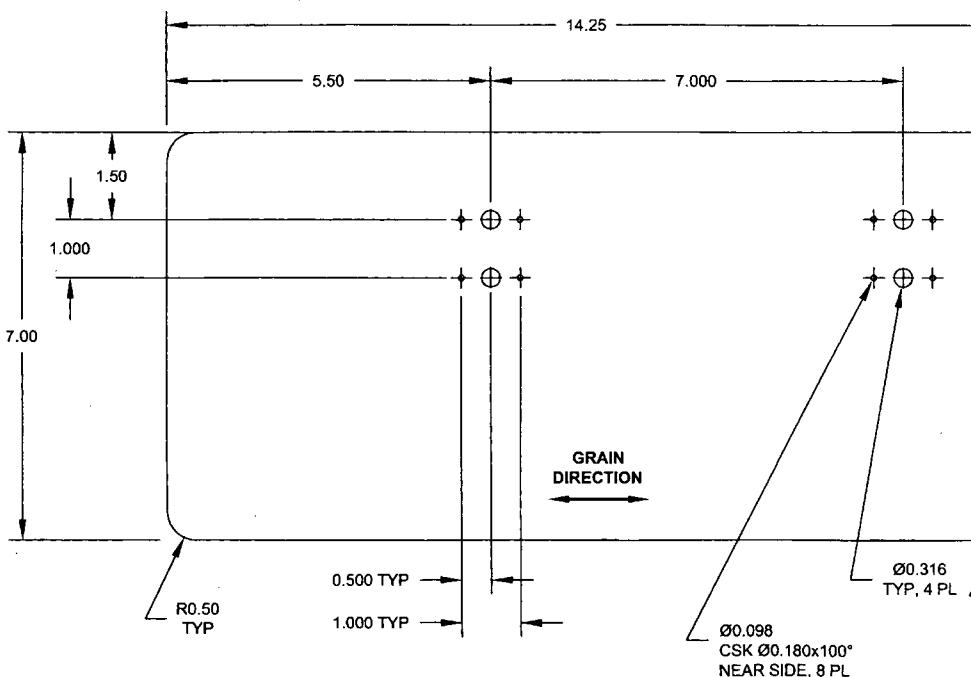
D

D

7.00

1.000

1.50

D3220-2 DOUBLER

B

B

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.050 THICK
REF DART SPEC. M2024T3S.050
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3220-2" USING REMOVABLE TAG
- 7) WEIGHT: 0.50 lbs

8 7 6 5 4 3 2 1

8 7 6 5 4 3 2 1

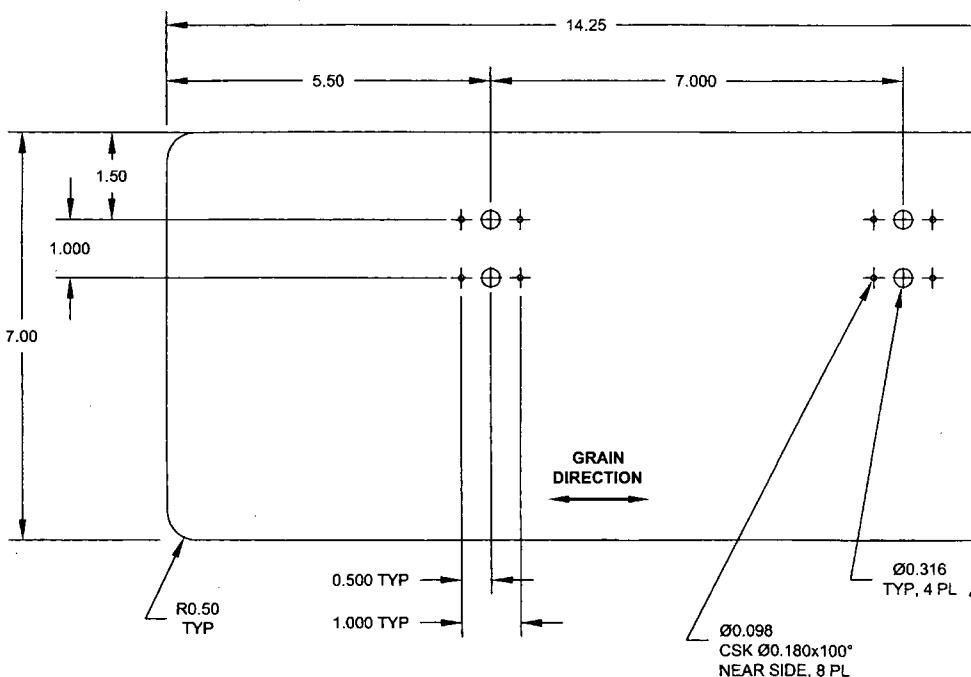
C

C

7.00

1.000

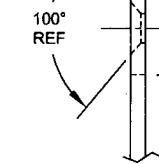
1.50

D3220-2 DOUBLER

B

B

B1-3
SEE DETAIL B
TYP



DETAIL B D2-3
SCALE 5X

RELEASED
2009-09-09
M

DESIGN	DS	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	✓	DRAWING NO.	REV. B
MFG. APPR.	✓	D3220	SHEET 3 OF 4
APPROVED	✓	TITLE	SCALE
DE APPR.	✓	DOUBLER	NTS
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A

A

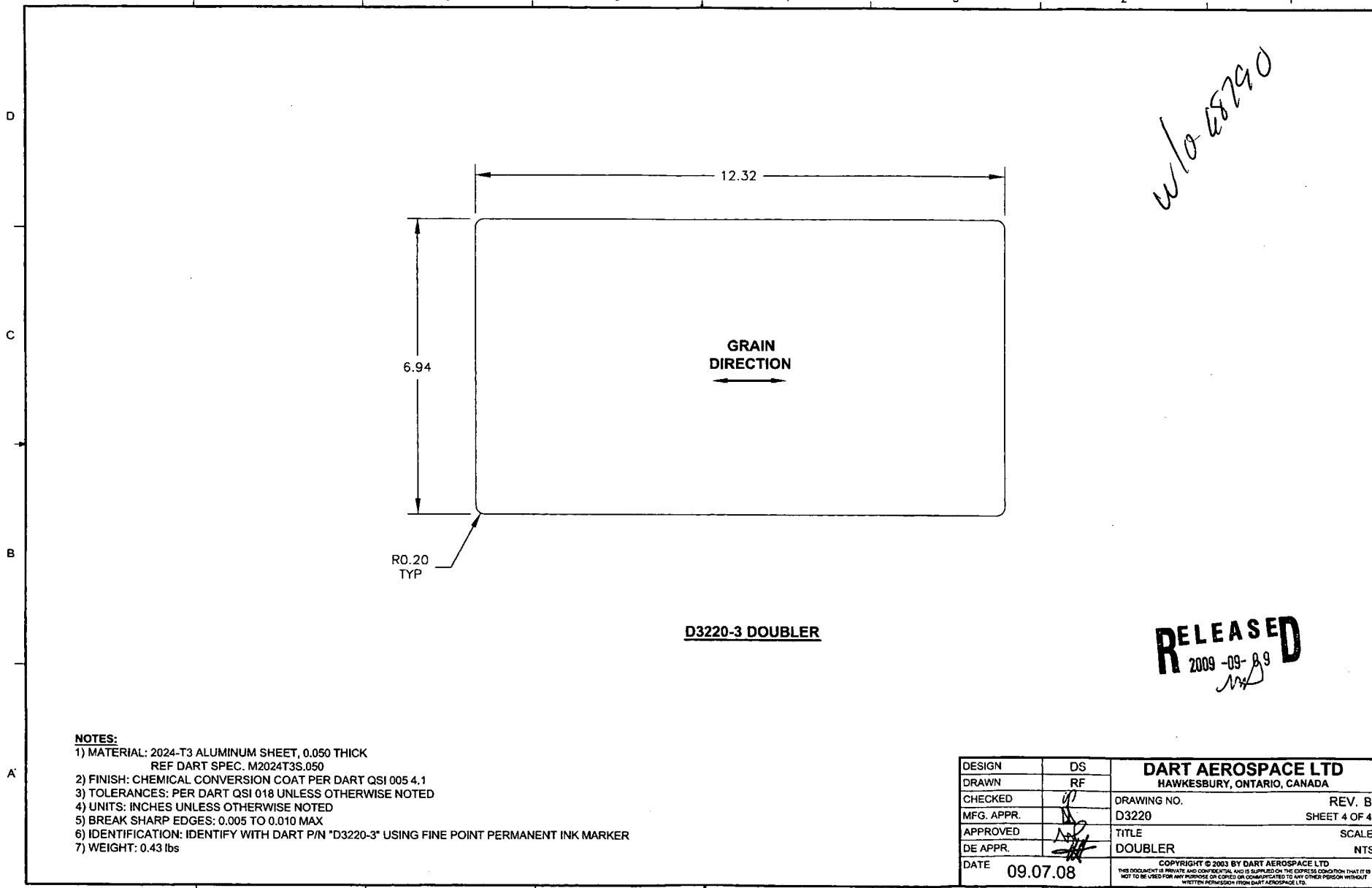
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8 7 6 5 4 3 2 1



8 7 6 5 4 3 2 1

DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	RF	
CHECKED	10	DRAWING NO. REV. B
MFG. APPR.	10	D3220 SHEET 4 OF 4
APPROVED	10	TITLE DOUBLER
DE APPR.	10	SCALE NTS
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